

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019731**Date Inspected:** 12-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

ZPMC personnel performing gouging of weld joint no: SEG3013M-257 [Edge beam (EB) 3048 to Floor Beam (FB) 3180, complete joint penetration (CJP) weld at panel Point (PP) 118.35)]. Gouging was done after Ultrasonic testing (UT) repair was identified by ZPMC. However, it was observed that the excavation was also done in the base metal (of FB3180) to almost the complete thickness of FB3180. This QA Inspector informed this to ZPMC CWI Li Ming Yang. ZPMC CWI agreed that the repair welding will be done with proper Critical Welding Repair Report (CWR) for this weld joint. See attached photos for further information.

ZPMC personnel performing gouging of weld joint no: SEG3013K-123 (EB3048 to FB3184, CJP weld at PP119-1500). Gouging was done after UT repair was identified by ZPMC. However, it was observed that the excavation was done more than 65% of the weld metal. This QA Inspector informed this to ZPMC CWI Li Ming

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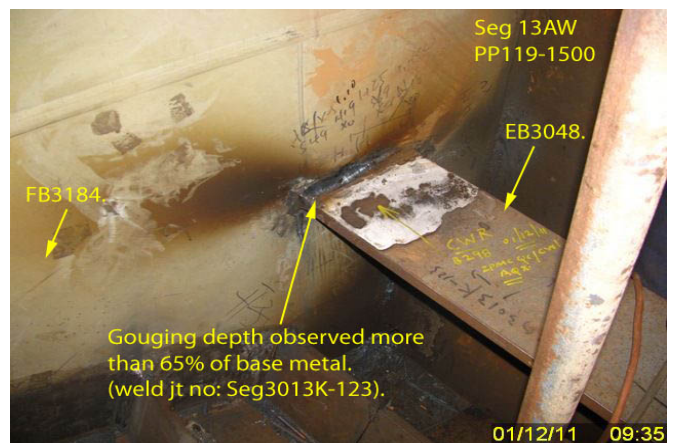
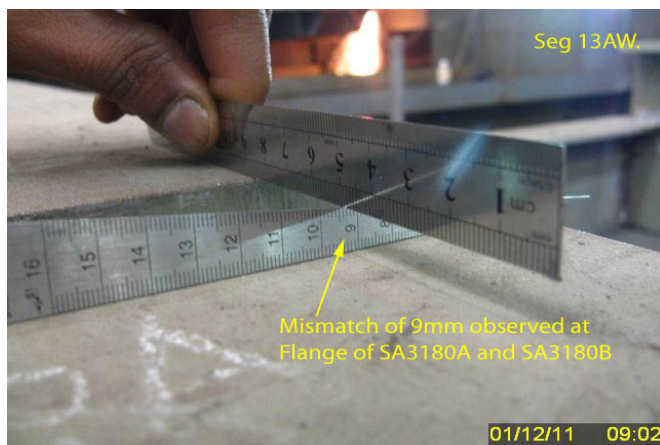
Yang, ZPMC CWI agreed that the repair welding will be done with proper CWR for this weld joint. See attached photos for further information.

During random inprocess visual inspection of Sub-Assemblies (SA plates) at PP119, this QA Inspector observed that the flanges of the below mentioned SA plates are misaligned. Details are as mentioned below.

- 1) SA3181A to SA3181B: 6mm.
- 2) SA3180A to SA3180B: 9mm.
- 3) SA3179A to SA3179B: 4mm.
- 4) SA3177A to SA3177B: 8mm.

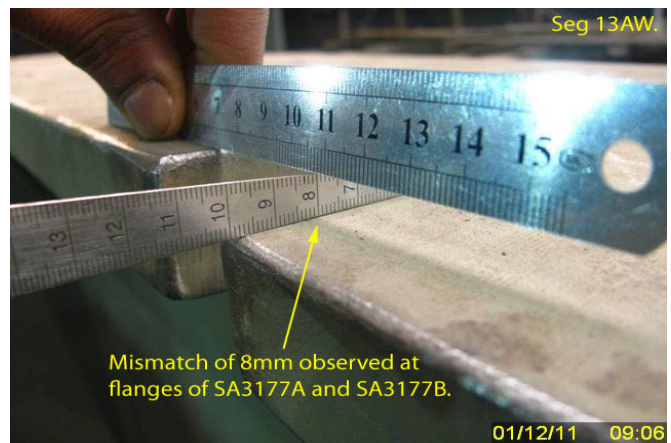
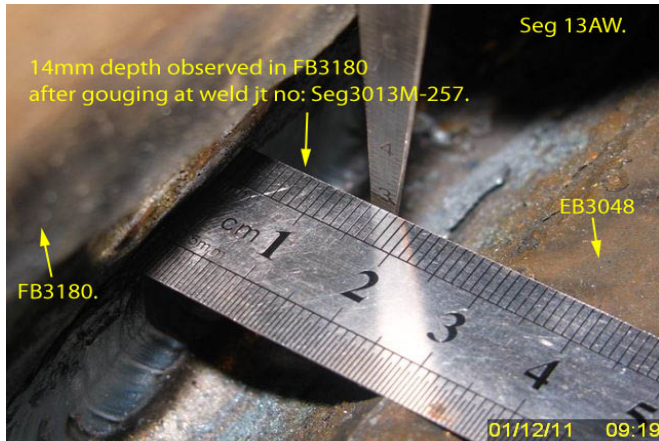
See attached photos for further information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh
Reviewed By: Patterson,Rodney

Quality Assurance Inspector
QA Reviewer